

Date: Friday, 9/1/2006 12:17:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 28404		
Estimate Number	: 10818		
P.O. Number	: N/A	Part Number	: D26651
This Issue	: 9/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2665 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27965	Drawing Revision	: C
		Material	: N/A
Written By	: <u>SA 06.09.01</u>	Due Date	: 9/30/2006
Checked & Approved By	: <u>SA 06.09.01</u>	Qty:	12 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88"
Grain Along Long 7.88 Length Batch no B25348

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1-Inspect part number and batch number are programmed correctly.
3-Fixturing Inspection last completed on 06.09.14 by SA
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr SA 06.09.14

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet SA 06.09.14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 06.09.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DP* Date: 06/10/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 28404

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Am 06-09-27

(12)

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y 06/10/02 x12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/02 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 345

06/10/02 (12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/03 (12)

Job Completion



u 06-003

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28404
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.124	.123	.122		
B	0.100	0.140		.124	.127	.123	.124		
C	1.125	1.145		1.134	1.133	1.133	1.137		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.255	.250	.250		
F	1.313	1.343		1.326	1.326	1.326	1.326		
G	0.210	0.230		.218	.227	.223	.222		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.569	1.572	1.572		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.106		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.007	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.792	.794	.793		
W	0.540	0.560		.548	.550	.547	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.925	.925	.926	.925		
AA	0.490	0.510		.492	.499	.498	.520		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA
Date: 06.09.14

Audited by: En
Date: 06/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28404
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.122	.123	.122		
B	0.100	0.140		.120	.122	.122			
C	1.125	1.145		1.135	1.135	1.136	1.156		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.250	.250	.251		
F	1.313	1.343		1.328	1.328	1.328	1.320		
G	0.210	0.230		.223	.223	.223	.222		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.570	1.571	1.573	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.105		
M	0.990	1.010		1.001	1.000	1.000	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.001	5.995	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.791	.794	.792	.794		
W	0.540	0.560		.549	.549	.549	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.929	.926	.925	.924		
AA	0.490	0.510		.499	.500	.497	.495		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: E
Date: 06.09.14	Date: 06/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

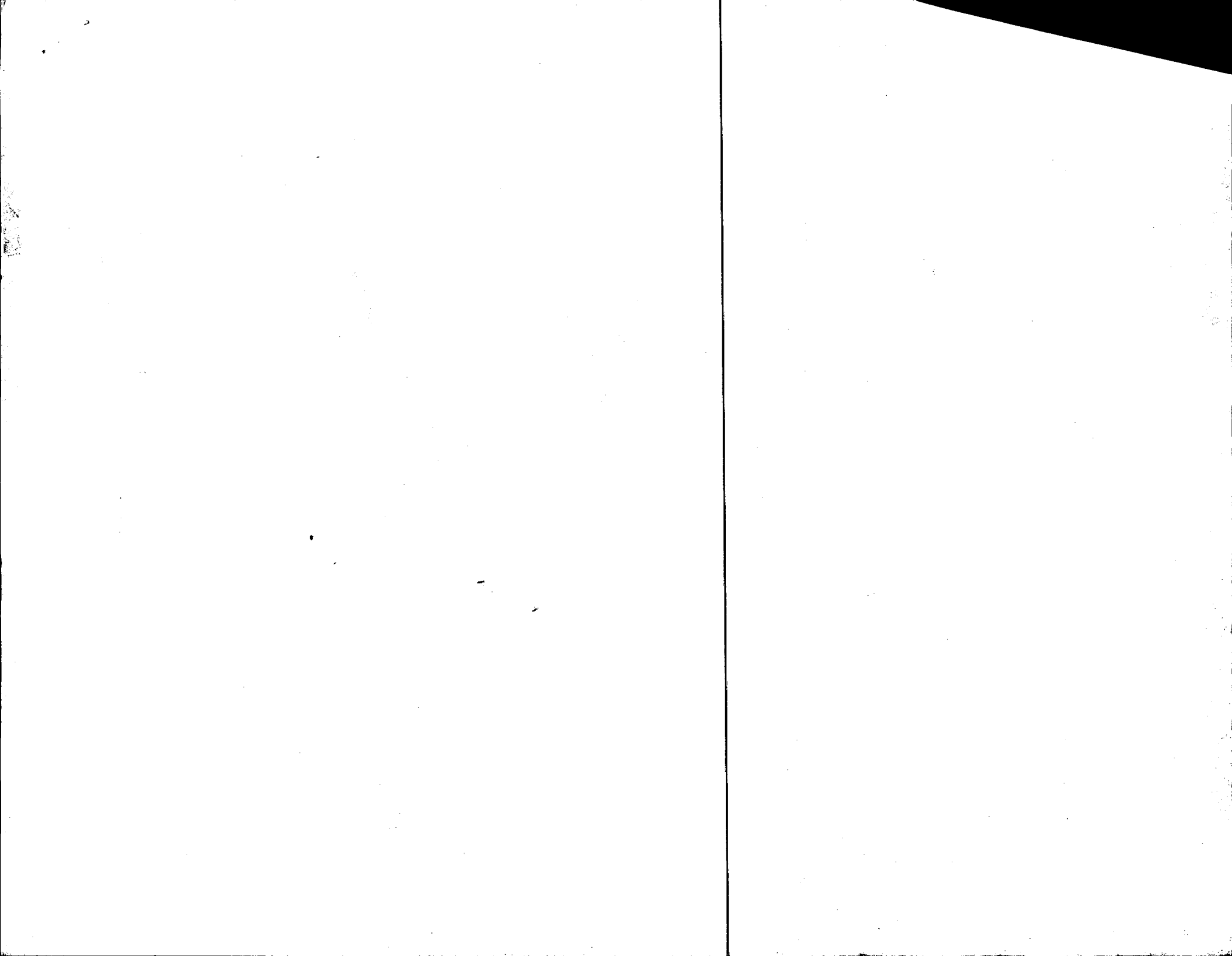
DART AEROSPACE LTD	Work Order: 28404
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1





Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.123	.123	.124		
B	0.100	0.140		.122	.122	.123	.127		
C	1.125	1.145		1.136	1.139	1.135	1.136		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.249	.250	.251	.254		
F	1.313	1.343		1.326	1.327	1.325	1.326		
G	0.210	0.230		.223	.223	.223	.224		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.573	1.575	1.572	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.105		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.000	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.795	.798	.797		
W	0.540	0.560		.550	.549	.547	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.921	.921	.920		
AA	0.490	0.510		.498	.494	.496	.496		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

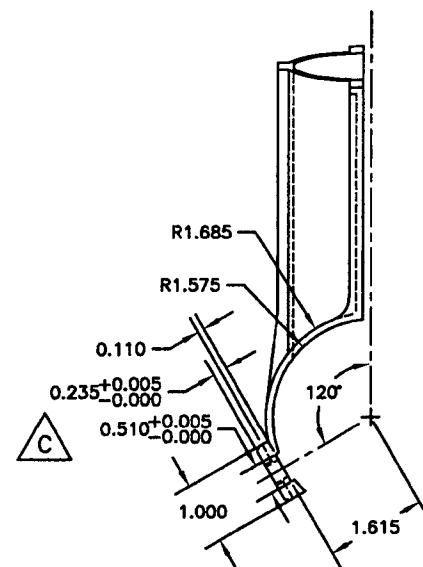
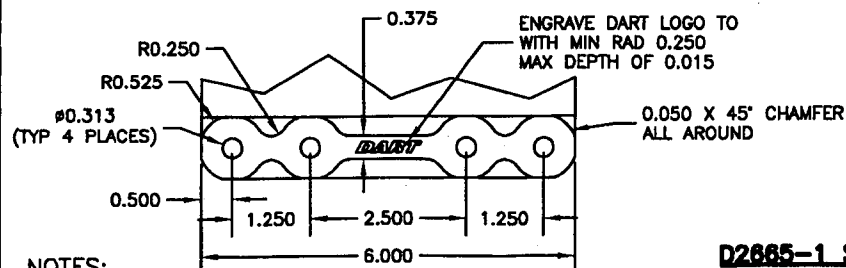
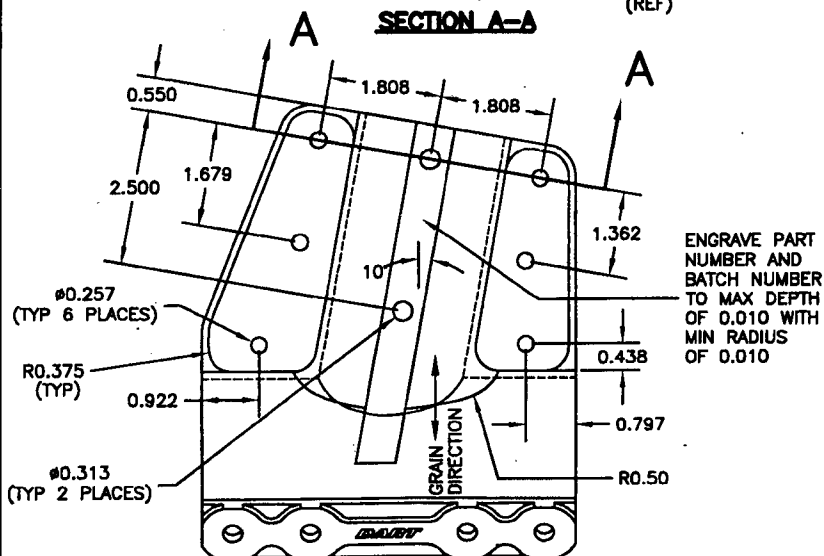
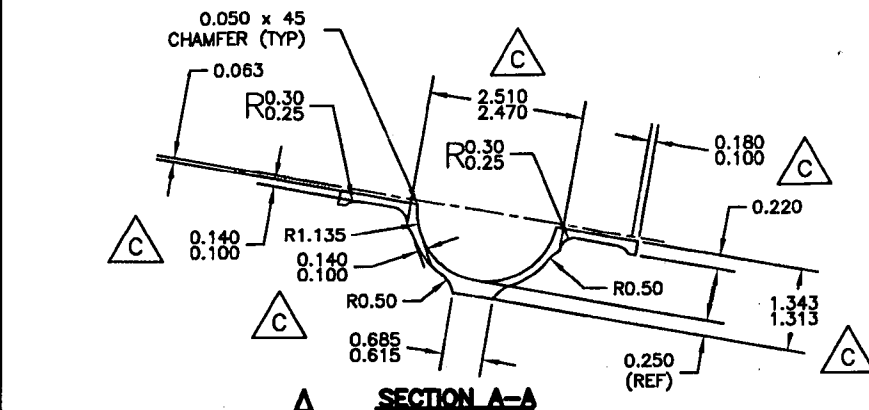
Measured by: SD	Audited by: En
Date: 06-09-16	Date: 06/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	




DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2665 REV. C SHEET 1 OF 1	
DATE 06.05.29		TITLE SADDLE FWD OUTSIDE HIGH SCALE 1:3			
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.29		INCORPORATE DEO 9122, 9102, 9095		

RELEASED
06.06.28



NOTES:

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1 
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
6) ALL DIMENSIONS ARE IN INCHES

D2665-1 SADDLE FWD OUTSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
HIGH UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28404

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